Dart Aerospace Ltd.

Date: Tuesday, 05/05/2009 12:56:15 PM
User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	**Drawing Name**	: WEDGE
Job Number	: 47737		
Estimate Number	: 13916		
P.O. Number	:	**Part Number**	: D39261
This Issue	: 05/05/2009 **S.O. No.** :	**Drawing Number**	: D3926 PREL
Prsht Rev.	: NC	**Project Number**	: N/A
First Issue	: / / **Type** : SMALL /MED FAB	**Drawing Revision**	: PREL
Previous Run	:	**Material**	:
Written By	:	**Due Date**	: 07/05/2009 **Qty:** 2 **Um:** Each
Checked & Approved By	: JW 09.05.01		
Comment	: Est Rev: A New Issue 09.05.01 EC verified: DD		

PRELIMINARY ISSUE

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	WATER JET	FLOW WATER JET

Comment: FLOW WATER JET
1-Cut as per Dwg D3926
Dwg Rev: PRE
Prog Rev: Lim HB 9-5-8

~~PRE 8 0 3~~ HB 9-5-8
M111695 HB 9-5-1

2-Deburr if necessary

2.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE

HB 9-5-8 HB 9-5-8

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

3.0	QC8	SECOND CHECK

0905.12 (4)

Comment: SECOND CHECK

4.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: RW35/DAN 5/

ENGINEERING APPROVAL 09/06/13

5.0	QC21	FINAL INSPECTION/W/O RELEASE

09/09/02

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

POSITIVE RECALL MF 09-06-23
EFFECTIVE 09.06.06 AUTH
RELEASED DATE 09/09/02

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector
		Material: M Delrin B 1000 X 040 7.5" ea. batch: 111695 Permanent chg.					
29.Nov.11		one taken by Sign for show	CP				

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Preliminary MP ECN 09-587P

~~PROTOTYPE~~ REQUEST FORM

DART Aerospace Ltd.

Product #: D350-636-105 **Job #:** 00285A **Date:** 09-05-01

Product Name: Wedge Kit **Requested By:** MP for HS

Design Manager Approval: MP

Quantity	Part Number	Category	Description	Drawing Date	Material Cert Req'd?	Due Date	Comments	Date Completed
2	D3926-1		Est Done Wegde	09.05.01	Y	May 7,2009		
1	DSI 9456		Est Done Wedge Kit	09.05.01	Y	May 7,2009	Please pull D2741 blade fittings from stock to install wedges	
							wedge kit.	

DART AEROSPACE LTD	Work Order:	47737
Description: WEDGE	Part Number:	D3926-1
Inspection Dwg: D3926-1 Rev: REV L		Page 1 of 1

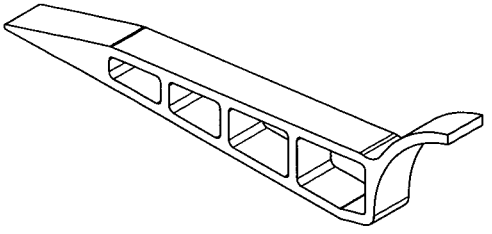
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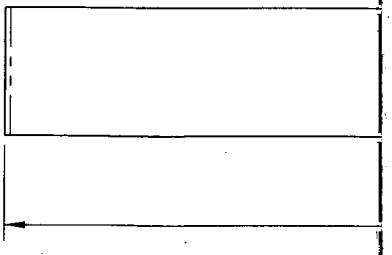
[X] First Article [] Prototype

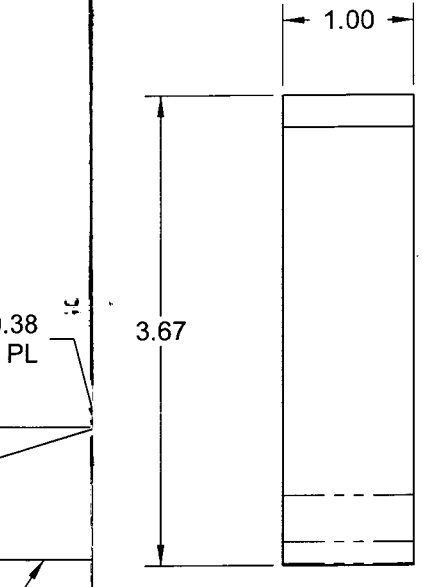
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.04	+/- .030	1.042	Y			
1.50	+/- .030	1.513	Y			
1.50	+/- .030	1.511	Y			
1.75	+/- .030	1.758	Y			
2.00	+/- .030	2.003	Y			
2.14	+/- .030	2.147	Y			
.25	+/- .030	.267	Y			
.25	+/- .030	.241	Y			
12.91	+/- .030	12.91	Y			
1.00	+/- .030	1.019	Y			
3.67	+/- .030	3.666	Y			

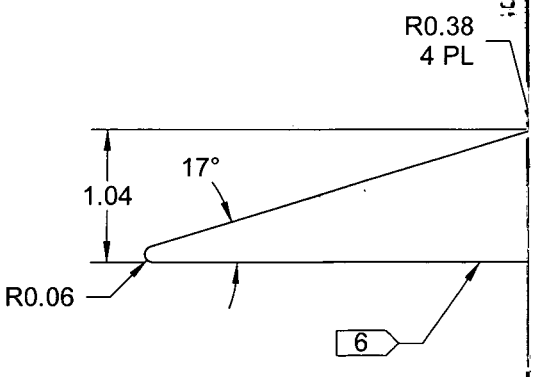
Measured by:	HB	Audited by:		Prototype Approval:	
Date:	9-5-11	Date:	09/05/12	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	









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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 47737

PRELIMINARY ISSUE
MP 09/05/07

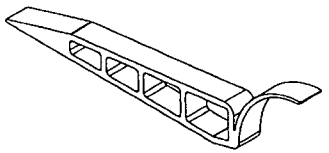
NOTES:
1) MATERIAL: BLACK DELRIN II 150E OR ACETRON
REF DART SPEC M-DELRIN-S
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHE
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D392
7) WEIGHT: 0.04 lbs

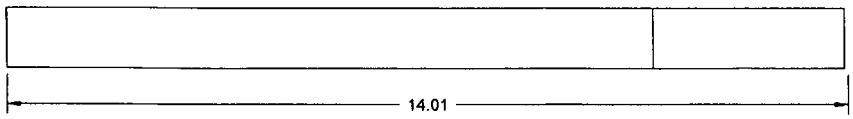
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DESCRIPTION	BY	DATE

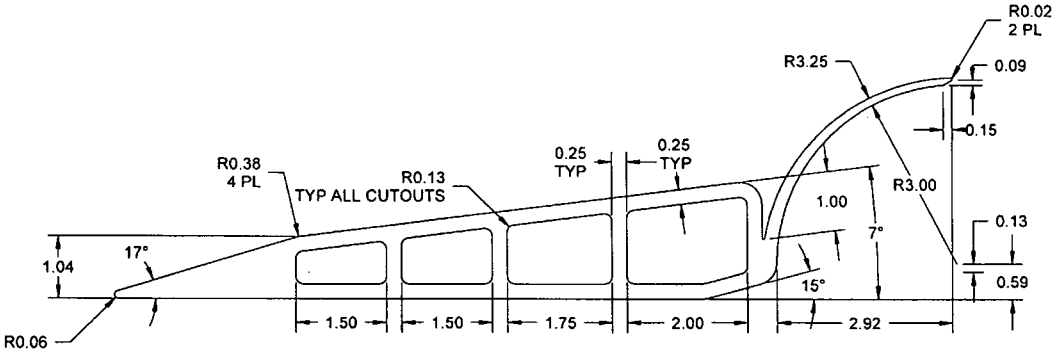
DART AEROSPACE USA, INC.
PORT HADLOCK, WA

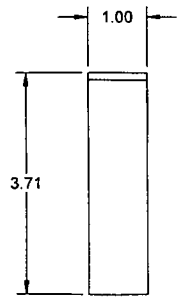
DRAWING NO. D3926	REV. A SHEET 1 OF 1
TITLE WEDGE	SCALE NTS

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47737

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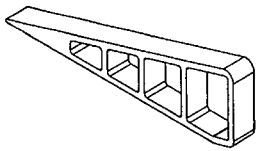
D3926-1 WEDGE

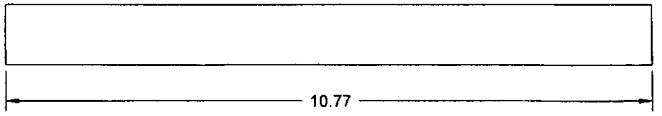
NOTES:
1) MATERIAL: 1.00" UHMW BLACK TIVAR 1000 VIRGIN MATERIAL
REF DART SPEC MUHMWB10
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3926-1" AND B/N USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.25 lbs

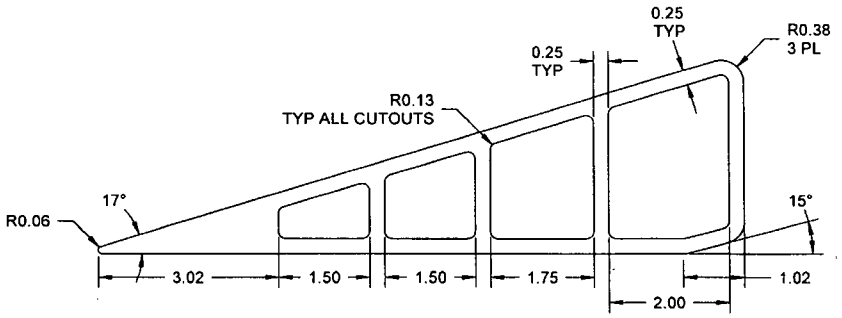
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A	NEW ISSUE		09.07.23

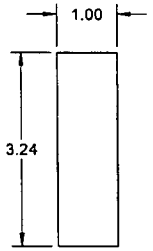
DESIGN		DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN			
CHECKED	AJS	DRAWING NO. D3926	REV. A
MFG. APPR.			SHEET 1 OF 2
APPROVED		TITLE WEDGE	SCALE NTS
DE APPR.			
DATE	09.07.23		

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47737

RELEASED
9/6/17

D3926-3 WEDGE

NOTES:
1) MATERIAL: 1.00" UHMW BLACK TIVAR 1000 VIRGIN MATERIAL
REF DART SPEC MUHMWB10
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3926-3" AND B/N USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.25 lbs

DESIGN		**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
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DATE 09.07.23		

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